

Work Order ID 52400

Tuesday, September 22, 2009 11:23:08 AM



Page 1

Item ID: D206-642-441

Accept



Setup Start



Revision ID: F

Stop



Item Name: Replacement Skidtube

Start Date: 9/23/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 10/15/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

RL

Date: 09/22

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D2650

Rev.F

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D206-642-441 CHG002 *N/A*

N/A

110

0.00



Skid tubes

Skid tubes

Memo

0.00

Skid tubes

1-Deburr Fwd edge of tube 2-Remove ridge on inside of Fwd edge of tube as per Dwg D2650 3-Weld Fwd Cap as per Dwg D2650. Use aluminum rod. Grind D2647 to fit as required. 4-Grind weld flush to cap on top surface only. 5-Cut af *m107213* *m111999*

MB 09-10-08

2E 09/10/13

120

0.00



Chemical Conversion Coat per QSI005 4.1

HandFinish

Memo

0.00

Hand Finishing

1 - AWM 9-10-14

B-52400

1-Deburr Fwd edge of tube

2-Remove ridge on inside of Fwd edge of tube as per Dwg D2650

3-Weld Fwd Cap as per Dwg D2650. Use aluminum rod. Grind D2647 to fit as required.
A/R Aluminum Rod _____

4-Grind weld flush to cap on top surface only.

5-Cut aft end 138.60" from front of tube

6-Drill pilot holes using drill jig DT8025 & DT8169 (A,B,C,D). Open to $\varnothing 0.312$ ".

7-Drill holes for wearplates using DT 8028-7. Open to $\varnothing 0.297$ ".

8-Open using #6 Drill Bit

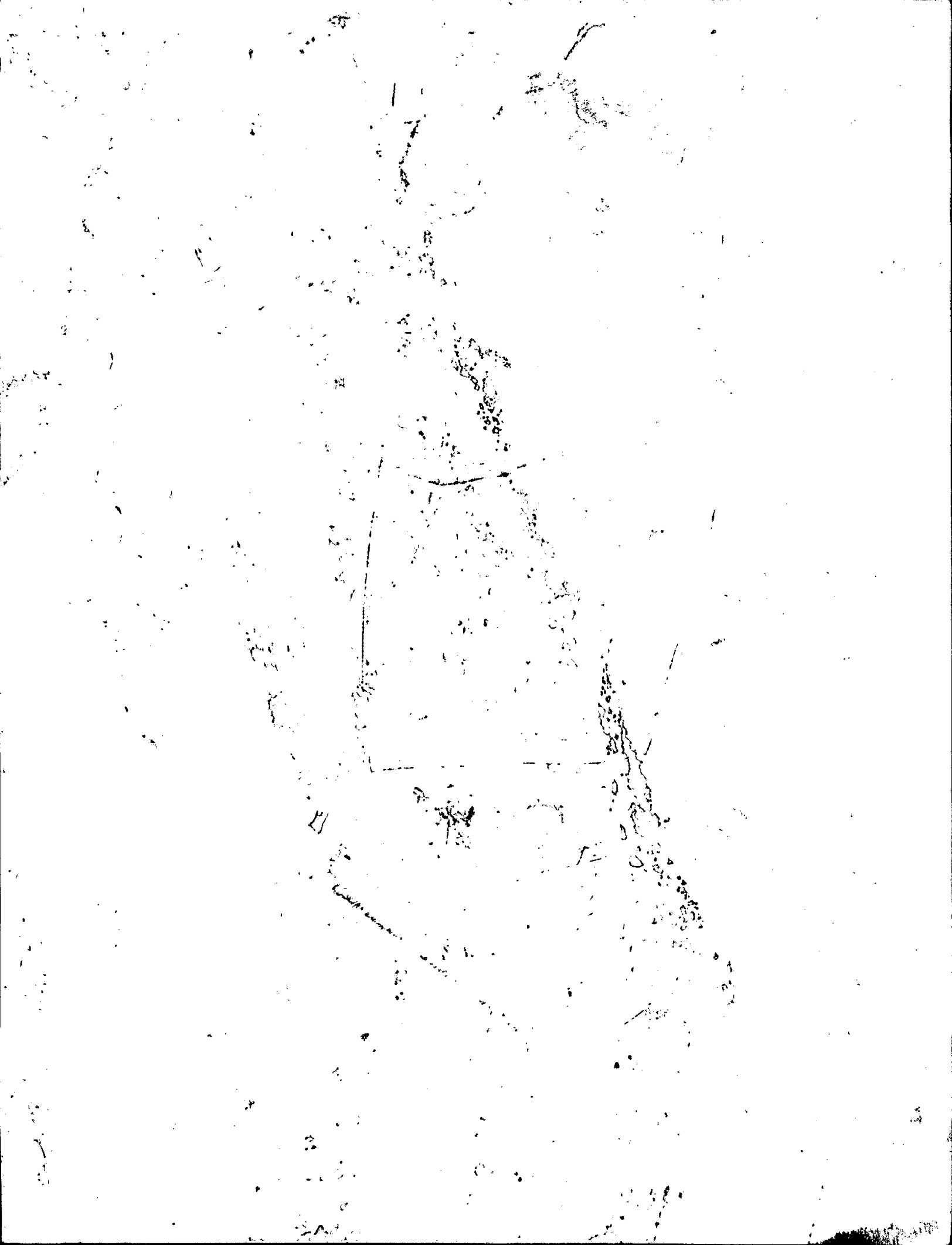
9-Open holes for Tow Ring to $\varnothing 0.625$ " as per Dwg D2650, D2650-7 Drilling Detail

10-Remove inner indexing ridge on aft end of skid tube as per Dwg D2650

11-Deburr and Blow out all chips from inside the tube

10/12/16

Awm
9-10-14



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Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

130

QC3- Inspect Part Finish

0.00

QC

Quality Control

Memo

DD
9-10-14

0.00

140

Skidtubes

0.00

Skidtubes

Skidtubes'

Memo

1-Open holes to finished size as per Dwg D2650, D2650-7 Drilling Detail
(without cutting fluid) 2-Countersink crossbolt spacer holes as per Dwg
D2650(without cutting fluid) 3-Deburr. Blow out chips. Grind alodine off
around crossbolt spacer. 4-Bond D26

0.00

- SKA FLEX - M112391

150

QC5- Inspect part completeness to step on W/O

0.00

QC

Quality Control

Memo

0.00

2) 8/10/15

1 - AWM 9-10-14

Ⓢ

6

Work Order ID 52400

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Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

160

0.00



Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1-Insert cross bolt spacers D2649. Weld as per QSI 004 and Dwg D2650.
Remember to back drill each hole to 0.25" before welding the other side. Use
aluminum rod. ☐ A/R Aluminum Rod M10x2.3 ☐ 2-Grind welds flush as
per Dwg D2650. ☐ 3-Counterbore 5/16"x

BE 09/10/15

- ANM9-10-16

170

0.00



HandFinish

HandFinishing

Memo

0.00

Hand Finishing

Install D2680-041 Nut Plate as per Dwg D2650

30061

1 ϕ - ANM9-10-9

180

0.00



QC

QC10- Inspect visual per QSI004- ground welds

Memo

0.00

Quality Control

=> Sorkolze



9/29/10/16

QC5

Inspect work. n/a

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Accept

Setup Start

Stop

Cust Item ID:

Customer:

Reference:

Run Start

Stop

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

**Insp.
Stamp**

0.00

Memo

0.00

2) 502/10/20

0.06

Memo

0.00

0.00
b6 09-10-20
0.00

0.00

Memo

0.00

START TIME: 7:15am ☐ OVEN TEMPERATURE: 320°F
7:45am ☐ FINISH TIME: 320°F

7:45am ☐ FINISH TIME:

 320°

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Item ID: D206-642-441

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Required Date: 10/15/2009 Req'd Qty: 1.00

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

220

QC3- Inspect Part Finish

0.00

BR 09-10-22

①

0.00

QC

Memo

Quality Control

230

HandFinishing

0.00

HandFinish

Memo

0.00

Hand Finishing

1-Install inserts & wearpads as per dwg D2922. Use a drop of Sikaflex inside insert holes before installing wearpad/wearplate. ☐ A/RSikaflex-291 11/23/91 ☐ Sikaflex expiry date: 10/20 ☐ 2-Install O-Rings D2651-3 on plugs D2651-1 with Petroleum Jelly

8 wing walk Batch: m/12/06

QC5- Inspect part completeness to step on W/O

0.00

240

QC

Memo

Quality Control

0.00

2) Sor/10/23

②

f

MD 09/10/23

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

250

0.00



Packaging

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D206-642-

441 ☐ Location: _____ ☐ PPP Rev: _____

PPP 52339 52373

260

0.00



QC

QC21- Final Inspection - Work Order Release

Memo

0.00

Quality Control

u 09.12.27

09/12/14

Picklist Print

Tuesday, September 22, 2009 11:23:07 AM

Page 1

Work Order ID: 52400



Parent Item: D206-642-441RevF



Parent Item Name: Replacement Skidtube

Start Date: 9/23/2009

Required Date: 10/15/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2620RevB		Manufactured	No			110	Each	19.0000	1.0000			
Skidtube, 206 Skidtube												

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

19

45898

19

D2646RevC

Manufactured No

120

Each

56.0000

1.0000



Aft Cap

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

56

20208

0

43801

1

46327

6

48109

49

D2647RevF

Manufactured No

140

Each

29.0000

1.0000



Cap

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

29

10773

7

43846

22

see attached

1 BE 09/10/13

1 BE 09/10/13

Picklist Print

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Start Date: 9/23/2009

Required Date: 10/15/2009

Comments:

Start Qty: 1.00

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Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D2654-7RevE1

Manufactured

No

160

Each

0.0000

1.0000



Web

CCR264SS3-3

Purchased

No

170

Each

271.0000

2.0000



Cherry Rivet

B-5280 (1*) AUM 9-10-19

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

271

111548

56

111827

115

112314

100

AUM 9-10-19 (2)

D2649RevB1

Manufactured

No

170

Each

711.0000

23.0000



Cross Bolt Spacer

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

LG

83

51529

83

Main Warehouse

ST

628

36013

5

47112

383

48271

240

23 88 09-10-15

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Page 2

Picklist Print

Page 3

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Parent Item: D206-642-441RevF



Parent Item Name: Replacement Skidtube

Start Date: 9/23/2009

Required Date: 10/15/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2680-041RevB1		Manufactured	No			170	Each	79.0000	1.0000			
Nut Plate												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	79	
33061	14	
44086	65	

- AWM 9-10-19

ALS4-1032-130

Purchased

No

230

Each

5,439.000

60.0000



Insert

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	5439	
110511	5439	

see attached
_____ h

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Start Date: 9/23/2009

Required Date: 10/15/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN960JD10L		Purchased	No			230	Each	6,445.000	62.0000			

Washer

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

6445

101291

16

104885

153

105793

236

109632

1040

110985

5000

see 2 Hazard u

Picklist Print

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Start Date: 9/23/2009

Required Date: 10/15/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN960JD416		Purchased	No			230	Each	7,793.000	1.0000			
Washer												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST	7793
102929	2
105906	4
106277	2
107321	23
107939	114
108161	553
108827	31
109249	69
110523	340
111279	101
111916	1959
112314	4595
16941	0

see attached
h

CR3212-4-03

Purchased

No

230

Each

314.0000 2.0000



Cherry Rivet

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST	314
111359	96
112314	200
15984	18

ANN 9-10-19 (2)

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Parent Item: D206-642-441RevF



Parent Item Name: Replacement Skidtube

Start Date: 9/23/2009

Required Date: 10/15/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2648-3RevD		Manufactured	No			230	Each	22.0000	6.0000			
Wearpad												

Warehouse
Location

Loc Qty

Loc Code

OFFSHORE

FG

12

45316

12

Main Warehouse

ST

10

21711

0

46957

10

D2651-1RevB

Manufactured No



Plug

230

Each

403.0000 22.0000



Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

403

43990

125

45490

28

51530

250

sell
Hatched

Picklist Print

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Start Date: 9/23/2009

Required Date: 10/15/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2651-3RevB		Manufactured	No			230	Each	1,035.000	22.0000			
O-Ring												

see attached

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

1035

43849

3

46114

1032

D2656-15RevD

Manufactured

No

230

Each

13.0000

1.0000



Wearshoe

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

Return 2009

6

45245

6

Main Warehouse

ST

7

45245

7

Handwritten signature

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Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D2656-23RevD

Manufactured

No

230

Each

20.0000

1.0000



Wearshoe

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

20

34597

1

43407

7

51468

12

D2656-37RevD

Manufactured

No

230

Each

18.0000

1.0000



Wearshoe

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

18

44550

13

46497

1

51469

4

Picklist Print

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Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3429-1RevA 		Manufactured	No			230	Each	22.0000	1.0000			
Wearpad												
				<u>Warehouse</u>				<u>Loc Qty</u>		<u>Loc Code</u>		
				<u>Location</u>								
				Main Warehouse								
				ST				22				
				44169				2				
				44579				20				
MS27039-1-08 		Purchased	No			230	Each	3,333.000	62.0000			
Screw												
				<u>Warehouse</u>				<u>Loc Qty</u>		<u>Loc Code</u>		
				<u>Location</u>								
				Main Warehouse								
				ST				3333				
				110467				192				
				110552				1141				
				110835				2000				
MS27039-4-06 		Purchased	No			230	Each	77.0000	1.0000			
Screw												
				<u>Warehouse</u>				<u>Loc Qty</u>		<u>Loc Code</u>		
				<u>Location</u>								
				Main Warehouse								
				ST				77				
				109061				77				

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5240

Status	Item ID	Rev	Name	Start Date	Quantity	UOM	P/D	Se	rap	Qun	men	N/C	ICX	Sort	time	Offset	D'lan	Typy	1 Per	Orurch	to Winore	Co3	Last I
✓	D2620	B	Skidtube, 206 Skidtube	1/01/08	1....	Ea		110	0	0.				0		0	MRP	B48159					6/0...
✓	D2646	C	Aft Cap	1/01/08	1....	Ea		120	0	0.	09/10/23	md		0		0	MRP	B48109	①				6/0...
✓	D2647	F	Cap	1/01/08	1....	Ea		140	0	0.				0		0	MRP						6/0...
✓	D2654-7	E1	Web	1/01/08	1....	Ea		160	0	0.				0		0	MRP						6/0...
✓	D2680-041	B1	Nut Plate	1/01/08	1....	Ea		170	0	0.				0		0	MRP						6/0...
✓	CCR264SS3-3		Cherry Rivet	1/01/08	2....	Ea		170	0	0.				0		0	MRP						6/0...
✓	D2649	B1	Cross Bolt Spacer	1/01/08	23...	Ea		170	0	0.				0		0	MRP						6/0...
✓	D3536-15	A	Gasket	10/21/09	1....	Ea		230	0	0.	09/10/23	md		0		0	MRP	B48159	①				10/...
✓	D3536-23	A	Gasket	10/21/09	1....	Ea		230	0	0.	09/10/23	md		0		0	MRP	B47713	①				10/...
✓	CR3212-4-03		Cherry Rivet	1/01/08	2....	Ea		230	0	0.				0		0	MRP						6/0...
✓	D3537-3	C	Wearpad	10/21/09	1....	Ea		230	0	0.	09/10/23	md		0		0	MRP	B35697	①				10/...
✓	AN960JD416		Washer	1/01/08	1....	Ea		230	0	0.	09/10/23	md		0		0	MRP	M108161	①				6/0...
✓	D3535-23	B	Wearshoe	10/21/09	1....	Ea		230	0	0.	09/10/23	md		0		0	MRP	B48156	①				10/...
✓	D3537-1	C	Wearpad	10/21/09	6....	Ea		230	0	0.	09/10/23	md		0		0	MRP	B31624	①				10/...
✓	D2651-1	B	Plug	1/01/08	22...	Ea		230	0	0.	09/10/23	md		0		0	MRP	B43990	②				6/0...
✓	MS27039C1-08		SCREW	10/21/09	60...	Ea		230	0	0.	09/10/23	md		0		0	MRP	M19185	⑥				10/...
✓	MS27039-1-08		Screw	1/01/08	2....	Ea		230	0	0.	09/10/23	md		0		0	MRP	M110467	②				10/...
✓	D2651-3	B	O-Ring	1/01/08	22...	Ea		230	0	0.	09/10/23	md		0		0	MRP	M46114	②				6/0...
✓	D3536-37	A	Gasket	10/21/09	1....	Ea		230	0	0.	09/10/23	md		0		0	MRP	B47375	①				10/...
✓	ALS4-1032-130		Insert	1/01/08	60...	Ea		230	0	0.	09/10/23	md		0		0	MRP	M112772	⑥				7/2...
✓	MS27039-4-06		Screw	1/01/08	1....	Ea		230	0	0.	09/10/23	md		0		0	MRP	M109001	①				6/0...
✓	D3535-37	B	Wearshoe	10/21/09	1....	Ea		230	0	0.	09/10/23	md		0		0	MRP	B47374	①				10/...
✓	AN960JD10L		Washer	1/01/08	62...	Ea		230	0	0.	09/10/23	md		0		0	MRP	M109632	①				6/0...
✓	D3535-15	B	Wearshoe	10/21/09	1....	Ea		230	0	0.	09/10/23	md		0		0	MRP	B48155	①				10/...

BOM's
updated
this sheet
signed/initial
I.P. updated

Location/Lot Activity

December 15, 2009 3:01:59 PM

Page 1 of 1

Criteria : All Items All Locations Lot: 52400 All Transaction Types All Dates Report on Locations & Lots

Transaction Type	Item ID/ Item Name	Warehouse Location ID	Reason	Employee ID Location Code	Loc Trans Date	LocQtyPrior/ Location Qty	Lot Number	LotQtyPrior/ Lot Qty	Shelf Life Date Lot Code	Extended Cost
Account Value Change	D206-642-441RevF / Replacement Skidtube	Main Warehouse FG		LACE01		7.0000		1.0000		
					10/27/09	-7.0000	52400	-1.0000		-\$1,198.63
		Main Warehouse FG		LACE01		7.0000		1.0000		
					10/27/09	7.0000	52400	1.0000		\$1,198.63
								0.0000		\$0.00
Issue	D206-642-441RevF / Replacement Skidtube	Main Warehouse FG	52343	FAUT01		7.0000		1.0000		
					10/27/09	-1.0000	52400	-1.0000		-\$1,198.63
								-1.0000		-\$1,198.63
WIP Receipt	D206-642-441RevF / Replacement Skidtube	Main Warehouse FG	52400	LACE01		6.0000		0.0000		
					10/27/09	1.0000	52400	1.0000		\$1,198.63
								1.0000		\$1,198.63

D206-642-4412

QTY -1	QTY -3	QTY -5	QTY -7	PART NUMBER	DESCRIPTION
X				D2650-1	SKIDTUBE ASSEMBLY
	X			D2650-3	SKIDTUBE ASSEMBLY
		X		D2650-5	SKIDTUBE ASSEMBLY
			X	D2650-7	SKIDTUBE ASSEMBLY
1	1	1	1	D2600-1-160	EXTRUSION
1				D2654-1	WEB
	1			D2654-3	WEB
		1		D2654-5	WEB
			1	D2654-7	WEB
1	1	1	1	D2646	AFT CAP
1	1	1	1	D2647	CAP
17	18	19	23	D2649	CROSS BOLT SPACER
16	18	14	22	D2651-1	PLUG
16	18	14	22	D2651-3	O-RING
1	1	1	1	D2680-041	NUT PLATE
2	2			D3286-1	DOUBLER
2	2			D3286-3	STUD
42	44	54	60	ALS7-1032-130	INSERT (or AKS4-1032-130, ALS4-1032-130, ALS7-1032-130)
2	2	2	2	AN960JD10L	WASHER
2	2	2	2	CCR264SS3-3	RIVET
2	2	2	2	CR3212-4-03	RIVET
2	2	2	2	MS27039-1-08	SCREW
1	1	1	1	MS27039-4-06	SCREW
1	1	1	1	AN960JD416	WASHER
52	52			CR3212-4-04	RIVET

F

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RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 32400

RELEASED
08-07-23/17

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: -CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
-POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
-BLACK ANTI-SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) WELD PER DART QSI 004
- 9) DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
- 10) BOND WEB INTO OUTER TUBE WITH SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015
- 11) INSERT D2651-1 PLUG C/W D2651-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE)
- 12) DRILL Ø0.297 FOR ALS7-1032-130 INSERTS USING TEMPLATE DT8056-1 ON -1 TUBE, DT8056-3 ON -3 TUBE, DT8056-5 ON -5 TUBE, AND DT8056-7 ON -7 TUBE. INSTALL INSERTS AFTER FINISH.
- 13) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED





F	DRAWING UPDATED TO CURRENT STANDARDS. SHT 6 ADDED. ALL SECTION AND DETAIL VIEWS TRANSFERRED TO SHT 6. SHT 1 IN PL PART D2649 QTY UPDATED. SHT 6 SECT C-C GRIND INSTRUCTIONS DELETED FROM NOTE 7 (SEE NCR 239).	AJS	08.08.08
E	REMOVE CBORE, CHG DRILL, ADD CHAMFER	CP	06.03.30
D	REDRAW: INCCRP. DE09136/9153/9163 MOD GROUND HANDLING ON D2650-1/-3	CP	04.05.17
C	CHANGE HOLE PATTERN AND FRONT END	DS	97.10.29
B	AS MANUFACTURED CHANGES	DS	97.06.26
A	NEW ISSUE	DS	97.03.25
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE USA, INC	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2650	SHEET 1 OF 6
APPROVED		TITLE	SCALE
DE APPR.		206/407 SKIDTUBE ASSEMBLIES	NTS
DATE	08.08.08	COPYRIGHT © 1997 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

Technical drawing of a shaft assembly with the following dimensions and callouts:

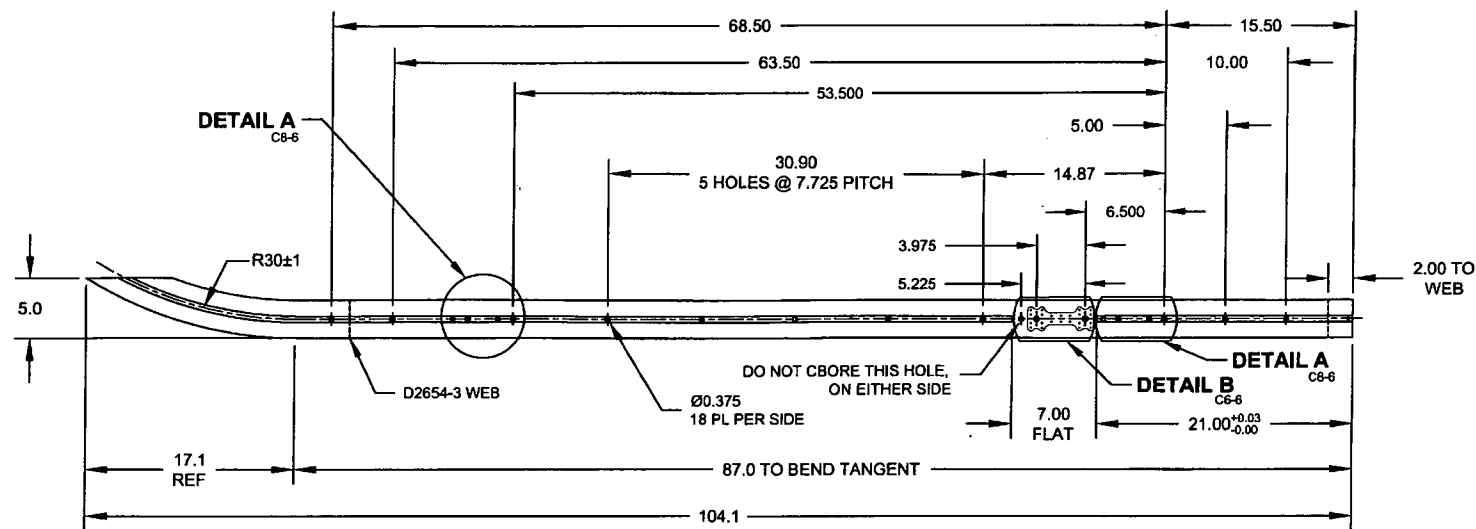
- Overall Dimensions:**
 - 63.85 (Total length)
 - 53.850 (Length to first hole)
 - 13.50 (Length to end of detail A)
 - 10.00 (Length to end of detail B)
 - 2.00 TO WEB (Distance to web)
 - 79.4 TO BEND TANGENT (Distance to bend tangent)
 - 96.5 (Total length)
- Local Dimensions:**
 - 5.0 (Vertical offset)
 - 17.1 REF (Reference distance)
 - 30.90 (Distance between hole centers)
 - 5.00 (Distance to hole center)
 - 15.22 (Distance to hole center)
 - 6.500 (Distance to hole center)
 - 3.975 (Distance to hole center)
 - 5.225 (Distance to hole center)
 - 7.00 FLAT (Flat length)
 - 19.00^{+0.03}_{-0.00} (Distance to end of detail B)
- Callouts and Features:**
 - DETAIL A C8-6** (Callout to the first hole)
 - DETAIL B C8-6** (Callout to the second hole)
 - 5 HOLES @ 7.725 PITCH** (Pitch of the five holes)
 - Ø0.375 17 PL PER SIDE** (Hole size and quantity)
 - NO CBORE THIS HOLE, ON EITHER SIDE** (Note on the hole)
 - D2654-1 WEB** (Callout to the web)
 - R30±1** (Radius of the bend)

[illegible]

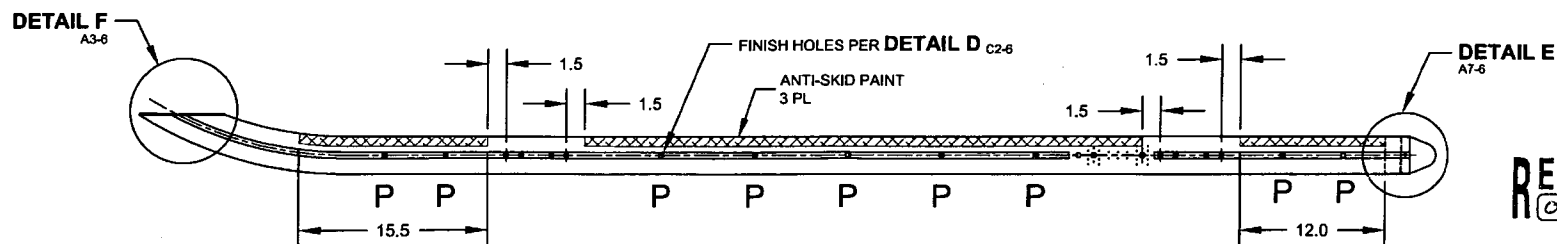
RELEASE
88-09-22 11/17

DESIGN	DS	DART AEROSPACE USA, INC	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. I
MFG. APPR.		D2650	SHEET 2 OF 2
APPROVED		TITLE	SCALE
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W/O 52400



D2650-3 BENDING/DRILLING DETAIL

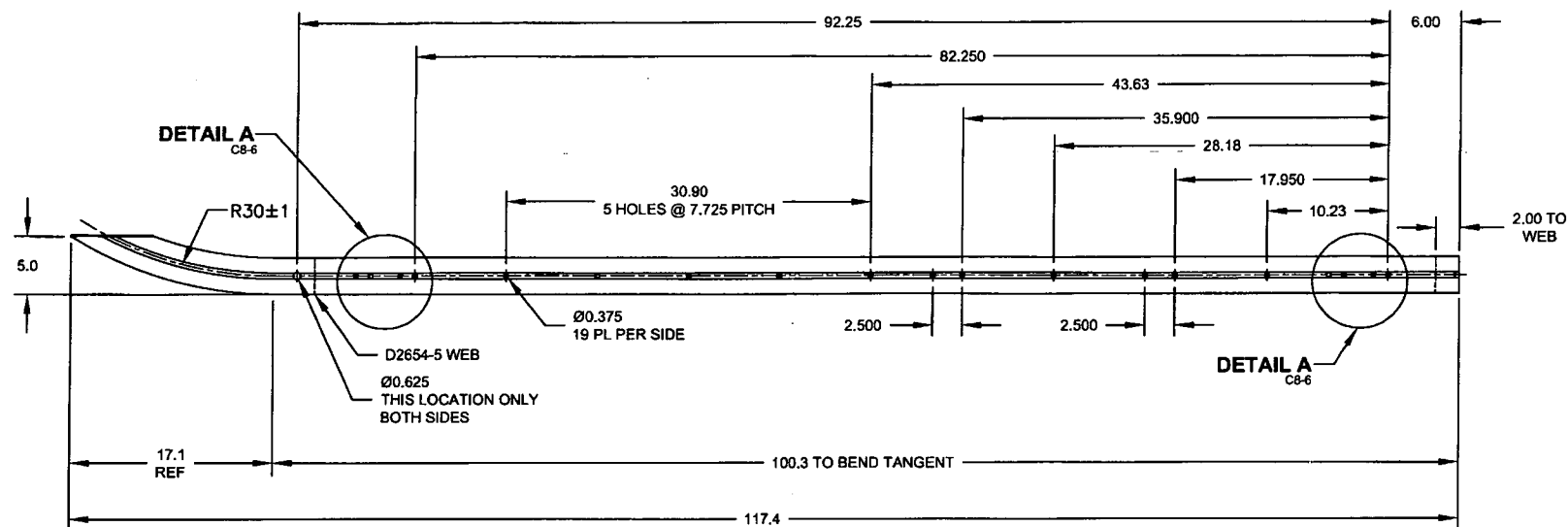


D2650-3 ASSEMBLY/FINISHING DETAIL

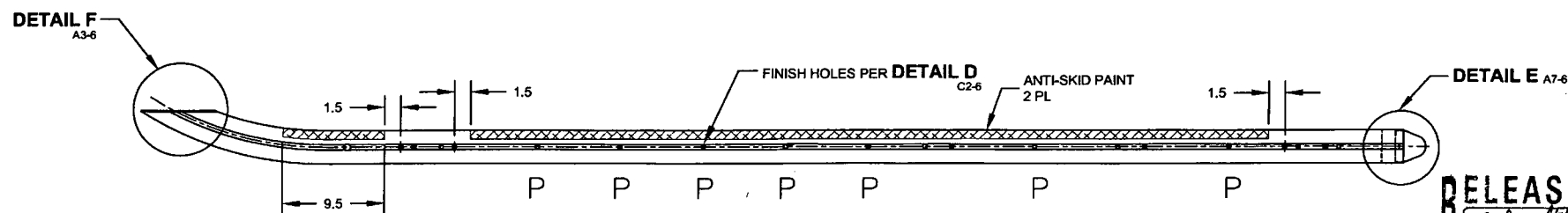
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08 07 22 118

DESIGN	DS	DART AEROSPACE USA, INC	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2650	SHEET 3 OF 6
APPROVED		TITLE	SCALE
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W/O 52400



D2650-5 BENDING/DRILLING DETAIL



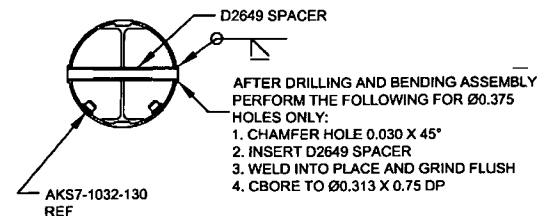
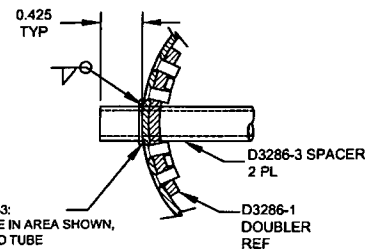
D2650-5 ASSEMBLY/FINISHING DETAIL

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08.08.08

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MFG. APPR.		D2650	SHEET 4 OF 6
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W/052400

SECTION C-C C7-6
SCALE NONE



DETAIL D
FOR Ø0.375 HOLES ONLY
SCALE 3X

B4-2
B4-3
B4-4
B4-5

DETAIL F NOTES:

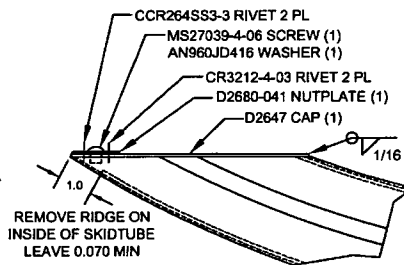
1. CUT TUBE LEVEL
2. REMOVE RIDGE ON FWD SIDE
3. LOCATE D2647 (TRIM AS NECESSARY)
4. WELD D2647 IN PLACE PER DART QSI 004
5. GRIND FLUSH
6. RIVET D2680-041 NUT PLATE IN PLACE

NOTE: MASK THREADS IN D2680-041 PRIOR TO FINISH

RELEASED
05-09-22-13

DETAIL F
SCALE NONE

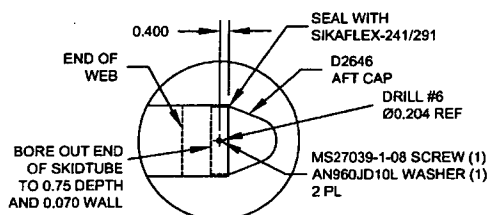
B8-2
B8-3
B8-4
B8-5



ORIENTATION OF
D2680-041

DETAIL E
SCALE 2X

B2-2
B2-3
B1-4
B1-5

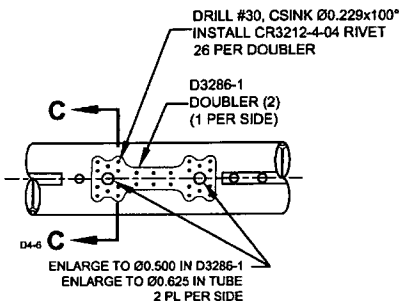


DETAIL A
SCALE 2X

C2-2
D7-2
C2-3
D7-3
C2-4
D7-4
C2-5
D6-5

DETAIL B
SCALE 2X

C3-2
C3-3



DESIGN	DS	DART AEROSPACE USA, INC	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2650	SHEET 6 OF 6
APPROVED		TITLE	SCALE
DE APPR.		206/407 SKIDTUBE ASSEMBLIES	NTS
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NO. 211

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliott
Job number: 52411
Part number: D206-642-541
Description: 206 skid
Welding Process: Tig[☒] Mig[]
Base material: Aluminum
Current: AC[☒] DC[]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[]
Penetration: pass[☒] fail[]

UNACCEPTABLE

Cracks: pass[☒] fail[]
Undercut: pass[☒] fail[]
Pin holes: pass[☒] fail[]
Overlap (cold lap): pass[☒] fail[]
Porosity (surface): pass[☒] fail[]
Coloration: pass[☒] fail[]

Qualifier Pct. Paul Date of Test Coupon 09-10-09
Welder Barclay Elliott Date of Test Coupon 09-10-09

The above named individual is qualified in accordance with AWS D17.1.2001 to weld